

stomer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT AS

Job Number: 40608

Part Number: PB674300115

Job Number:



Seq. #:

Machine Or Operation:

Description:
INSPECT WORK TO CURRENT STEP

20.0

QC5

INSPECT WORK TO CONTENT

(P2)



Comment: INSPECT WORK TO CURRENT STEP

21.0

PACKAGING 1

PACKAGING RESOURCE #1

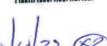


Comment: PACKAGING RESOURCE #1

Identify and Chark

Location:_

d welpny



22.0 QC21

FINAL INSPECTIONW/O RELEASE

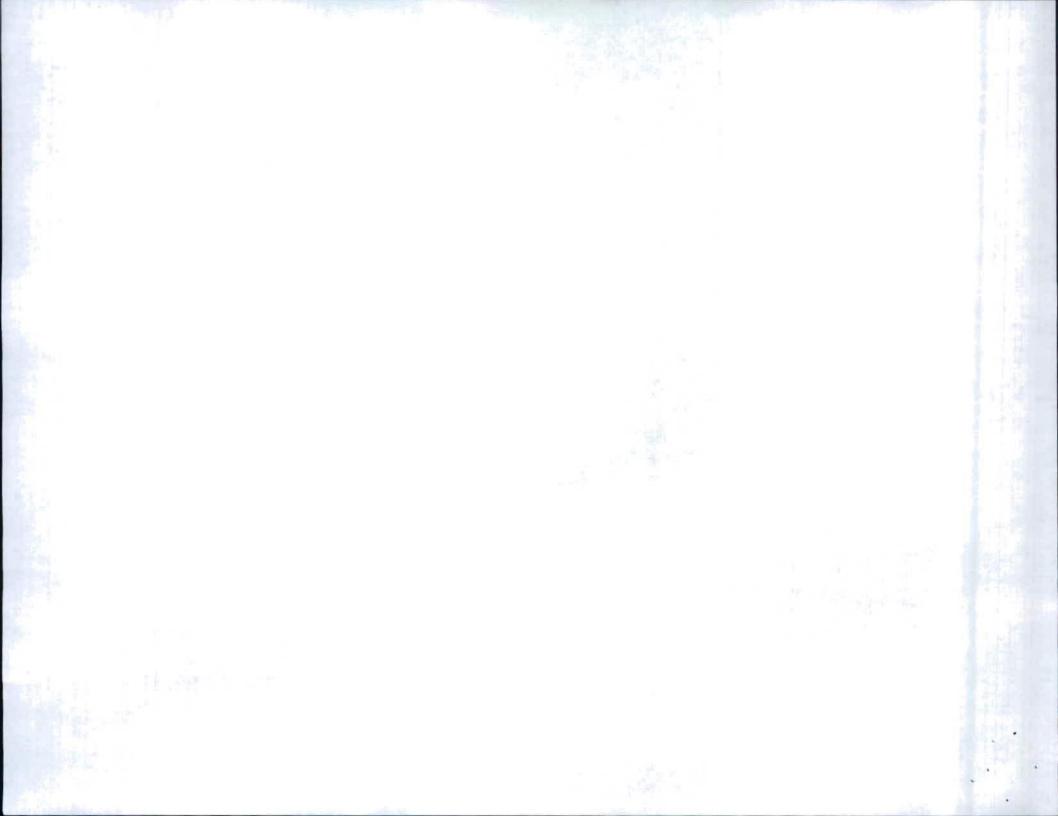


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JUF 08-16-23



Process Sheet

comer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115



Seq. #:

Machine Or Operation:

Description:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

14.0 QC3

INSPECT POWDER COAT/CHEM



DER COAT/CHEMICAL CONVERSION

PB674300173

batch:

PB674300183

20 Degree Cover Plate







Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)



20 Degree Cover Plate

PB67-43001-83



was Jone

Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

17.0

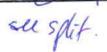
15.0

16.0

batch: MS27039110

PB67-43001-83

Screw



-66.

Comment: Qty.: Screw 8.0000 Each(s)/Unit

Total:

40.0000 Each(s)

NAS1149F0316F

· batch:

WASHER



WASHER



Comment: Qty.:

Total: 40.0000 Each(s)

08

19.0

18.0

batch: SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg



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anie Fauteux

Process Sheet

omer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40608

Part Number: PB674300115

Description:

Job Number:



Seq. #:

Machine Or Operation:

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

INSPECT WORK TO CURRENT STEP



8.0



WORK TO CURRENT STEP Comment: INSPE

HELICAL INSERT



9.0

MS124780



Comment: Qty.:

1.0000 Each(s)/Unit Total:



HELICAL INSERT

5.0000 Each(s)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE



Comment: SMALL & MEDIUM FAB RESOURCE 1

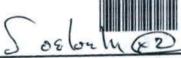
- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helicol
- 3- install helicol insert as per dwg

QC5 11.0

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



12.0

HAND FINISHING

HAND FINISHING RESOURCE #1



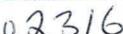


Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

POWDER COATING 13.0

POWDER COATING







Comment: POWDER COATING

- 1- MASK TUBE FROM BASE TO GUSSET
- 2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3



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: FWD ADJUSTABLE BLADE SUPPORT A

Thursday, 24/07/2008 8:23:49 AM

Melanie Fauteux

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 40608 - (

Estimate Number : 13433

P.O. Number

This Issue

: 24/07/2008 S.O. No. :

Prsht Rev. : NC

First Issue : 17/07/2008

Previous Run

Type

: LARGE FAB ASSY

Part Number **Drawing Number**

Drawing Name

: PB674300115 : B6743001 P.7

Project Number Drawing Revision

: N/A : B1

Material

Due Date

: 24/07/2008

Checked & Approved By

Comment

: Est Rev:A 08-06-26 new issue DD verified by:ec

Additional Product

Job Number:

Written By

Seq. #:

Machine Or Operation:

Description:

1.0

PB6743001257

Inner Tube

Comment: Qty.:

Inner Tube,

1.0000 Each(s)/Unit Total: 5.0000 Each(s)

batch: 40.585

2.0 PB6743001249

Inner Tube Bushing

Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Inner Tube Bushing batch: m12/47

PB6743001253

Gusset



Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

Gusset

batch: 340045



4.0

PB6743001254

Gusset



Comment: Qty.:

1.0000 Each(s)/Unit Total:

5.0000 Each(s)

5.0

PB67430017

Gusset

PB67-43001-71





batch: 546553

Comment: Qty.: 1.0000 Each(s)/Unit Total:

5.0000 Each(s)

PB67-43001-71

batch: 5 4000